

20-8680



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

648.3535

Job Sheet 214790



Part No: 648.3535

Job Qty: 50 pcs

Part Name: Fwd RH Girt Strip



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/20

Job Tracking No:

Due Date: 11/25/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 648.3500 REV C IPP REV:A 20.11.02 NEW ISSUE FK VERIFY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	50 pcs		11/20/20	0.17	5.00	Waterjet - Omax		OK 20/11/10
							Waterjet - Omax - SCH-S		
110	QC 2	50 pcs		11/20/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 20/11/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

DART
AEROSPACE

Part: 648.3535
Job No: 214790
Serial No/Batch: S312178
Revision: REV.C
Inspector:
Exp Date:
Instructions:

Container No: S312178

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/11/20

Plex 11/2/20 10:32 AM Dart.lajeunesse.marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
112	Small Fab - 2 - B4B	50 pcs	11/20/20	0.00 5.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
					Small Fab - SCH-B	
114	QC 5	50 pcs	11/20/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
					QC 5 - SCH-B	
120	NV5000 - 1 - B4B	50 pcs	11/24/20	1.00 50.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	
130	QC 2	50 pcs	11/24/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	

NOT REQUIRED



GCS 11/12/2020

see attached

mtrl berts req'd

DAS
82
9-89

NOV 12 2020

ALA

20/11/12

deburr & remove sharp edges

DAS
86
9-89

20/11/12

				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
140 QC 8	50 pcs	11/24/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	DAS
				QC 8 - 33	33 20/11/12
				QC 8 - 35	9-89
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
142 Small Fab - 2 - B4B	50 pcs	11/25/20	0.00 5.00	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	58 NOV 12 2020
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	

144 QC 5	50 pcs	11/25/20	0.00 0.00	Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
				Small Fab - SCH-B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
				QC 5 - SCH-B	
150 Packaging 3-1 - Stock - B4B	50 pcs <i>52 pcs. MAR</i>	11/25/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

DAS
82
9-89

NOV 12 2020

DAS
28
9-89

NOV 13 2020

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	50 pcs	11/25/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 112 - Mill holes chmfs as per DWG
 120 - 1-Machine as per folio FD412 FOLIO REV: AA DWG REV: C 2-Debur
 130 - QC2- Inspect parts off machine FAI/FAIB
 140 - QC8- Inspect parts - second check
 142 - Score surface, before applying primer, using 40 GRIT sand paper.
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

NOV 13 2020
 DAS 77
 9-89

GA-TBL

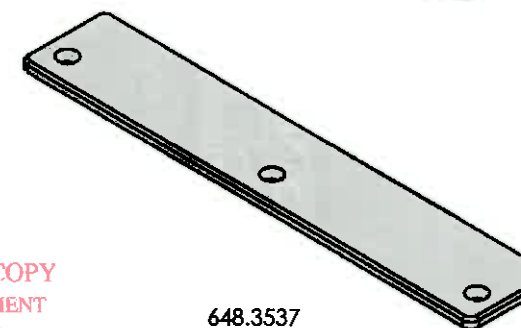
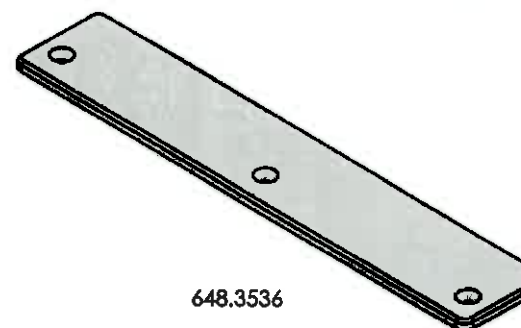
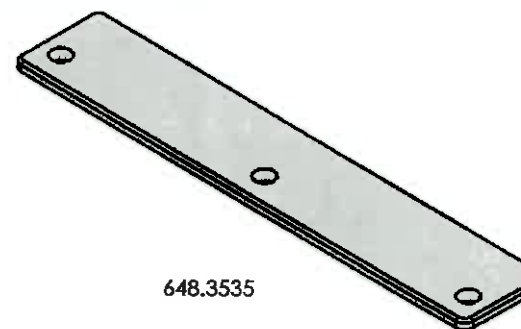
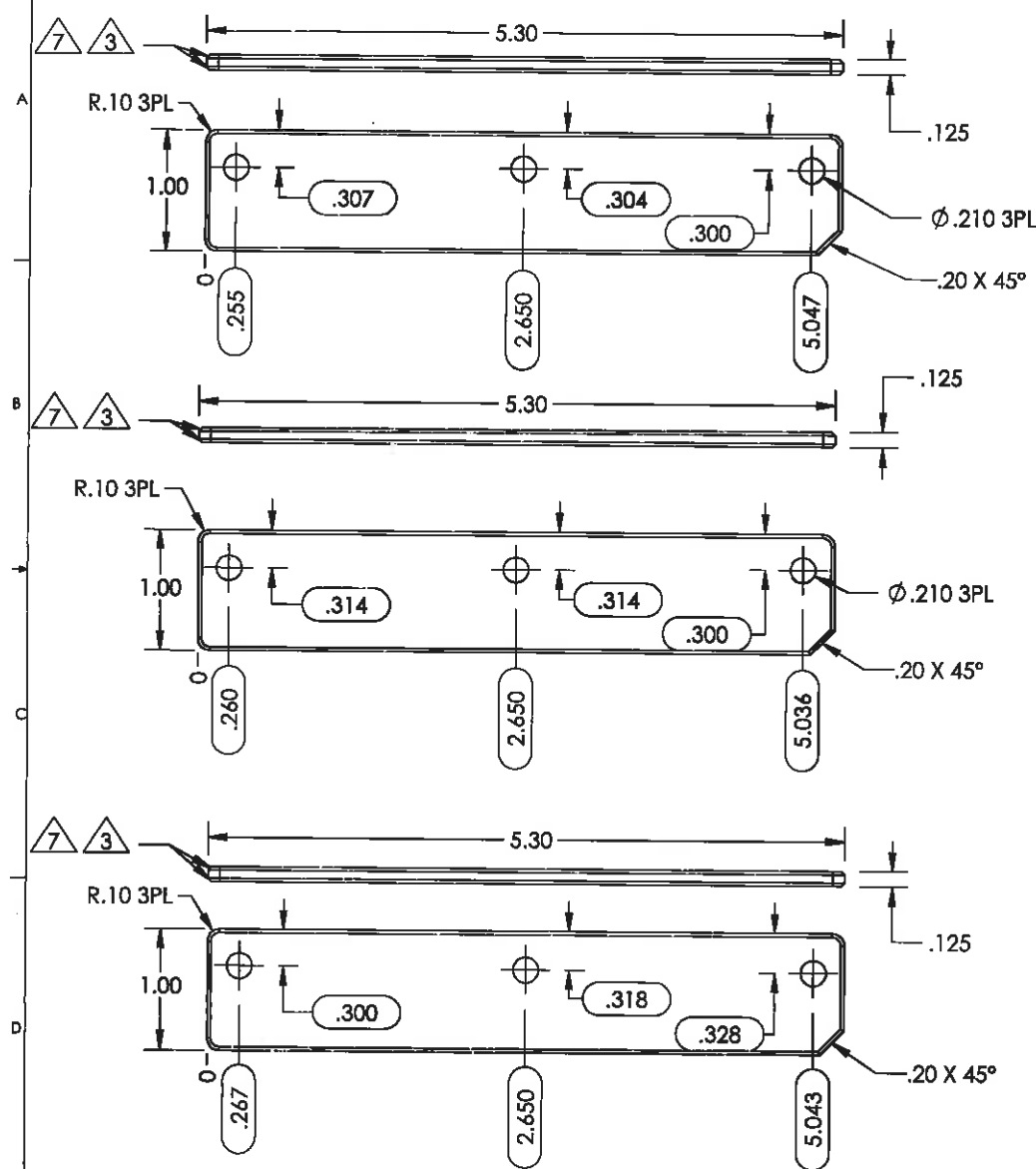
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M301S11GA-H50	301 SS Sheet - 1/2 hard 0.125	1.8500 sf (.037 ea)	100-Waterjet - Omax - 1	S302475

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M301S11GA-H50	2	22	0

Part Specifications	
Specifications could not be found.	

Plex 11/2/20 10:32 AM Dart.lajeunesse.marie

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DAA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DAA DART AEROSPACE IS PROHIBITED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 214790 MJS

20-11-02

ORIGINAL DATE 08-11-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY EAMERSON P. BAYO	CHECKED P. BAYO	APICAL INDUSTRIES, INC. DART AEROSPACE	
DRAWING APPROVAL P. BAYO		SHEETMETAL	
CONTRACT NO.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 648.3500
SCALE NONE		SHEET 8 OF 12	

ORDER NOTES

FAI measurements required for all parts on this order.
Lines 1-3 are priority.
Ship all lines Fedex Standard Overnight through account 198549495.

****CRITICAL REQUIREMENT TO DEBURR AND REMOVE SHARP EDGES****

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements.
Please visit www.dartaerospace.com for PO Terms & Condition and Quality Clause Standard Requirements for San Diego, CA, AIWI-7.4.1QCS
PO order acknowledgement required.

All items/services subject to our inspection and acceptance.

Packing slip required with each shipment.

Certificate of
Conformity
is required.

Material and Outside Process Certifications required with each shipment

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K8A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

Latest Revision Provided Unless Otherwise Requested

Plex 10/30/20 1:32 PM dart.crooks.caitlin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER				ORDER						
Customer Code: CAPIC01 Sold To: DART Aerospace Ltd - Vista 3030 Enterprise Court, Suite A Vista, CA 92081 USA Phone: 760-509-1617 Ship To: DART Aerospace Ltd - Vista 3030 Enterprise Court, Suite A Vista, CA 92081 USA Phone: (760) 724-5300				Order No : 30757 Date: 10/29/20 Ship-To Contact: Emie Navarro Email: enavarro@dartaero.com Cust PO No: POSD004481 FOB: Shipping Point Ship Via: Freight Terms: PrePaid Terms: Net 30 INCO Terms: Ex Works Order Taker: Tori Sera Order Taker Phone: Order Taker Email: tsera@dartaero.com						
Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price	
1	11/30/20	11/30/20	648.3535	Fwd RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all notes and flag notes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES	50	pcs	\$38.96USD	pcs	\$1,948.10 USD	
2	11/30/20	11/30/20	648.3538	Aft Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	25	pcs	\$14.62USD	pcs	\$365.41 USD	
3	11/30/20	11/30/20	648.3539	RH Aft Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES	25	pcs	\$14.55USD	pcs	\$363.69 USD	
4	11/30/20	11/30/20	648.3540	Fwd Girt Strip Build per DG /N648.3500 RevC. Adhere to allapplicable notesand flag noteson DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	100	pcs	\$10.28USD	pcs	\$1,028.10 USD	
5	12/7/20	12/7/20	648.3537	Aft RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	25	pcs	\$10.09USD	pcs	\$252.26 USD	
6	12/7/20	12/7/20	648.3536	Mid RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	20	pcs	\$38.96USD	pcs	\$779.24 USD	
7	11/30/20	11/30/20	MISC	MISCELLANEOUS Non RecurringCharge-Programmingfor 648.3537,648.3538,648.3539 &648.3540	4	pcs	\$78.00USD	pcs	\$312.00 USD	
8	11/30/20	11/30/20	MISC	MISCELLANEOUS Non-RecurringCharge-Programmingfor 648.3535 &648.3536	2	pcs	\$95.00USD	pcs	\$190.00 USD	
Sub Total									\$5,238.80 USD	
Grand Total									\$5,238.80 USD	

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M301S11GA

PO / BATCH NO.: POHB047051

DATE: SEP 23 2020

S 302475

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: .125

QUANTITY RECEIVED: 30 SF

THICKNESS RECEIVED: .125

QUANTITY INSPECTED: 30 SF

SHEET SIZE ORDERED: 3' x 10'

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: 3' x 10'

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	Y (N)	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	Y (N)	
CORRECT MATERIAL PER D-DRAWING	Y (N)	AMS 5518 / ASTM A666
CORRECT THICKNESS	Y (N)	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	Y (N)	HIT: 7592253
CORRECT MATERIAL IDENTIFICATION	Y (N)	
CORRECT M# ON THE MATERIAL	Y (N)	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

Testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: _____	DAS	SIGNED OFF BY: _____	
DATE: SEP 23 2020	82	DATE: _____	
		9-89	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in.

United Performance Metals

Paul Isaac
Paul Isaac
Quality Associate

Customer Name: TW Metals - Exton
Customer PO: M48426595
UPM Sales Order: 755822
Date: 3/17/2020
Description/Form: STAINLESS 301 1/2 HARD - SHEET
Heat Number: 7592253 Ingot: 19L00356506

Width: 36.0000 Length: 120.0000
Size: .1250
Customer P/N:
Packing List Number: 143346-1
Quantity: 1092 LB: 7 pc.

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 16 Coshocton, OH 43812 U.S.A.				Page: 1										
		Lead No. 5391843 Sm No. 5391843														
CUSTOMER	UNITED PERFORMANCE METALS INC 3475 SYMMES RD HAMILTON, OH 45015		S H E E T	UNITED PERFORMANCE METALS ONEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 45015		MILL ORDER NO. 271940-3395 PROCESSOR ORDER NO. CIN-35336-P14 BUYERS ORDER NO. CIN-35336-P14										
						PART NO.										
						ENGLISH UNITS - PRODUCT - METRIC UNITS .1250 NOM 36.0000 X 120.0000										
LIST ID	PIECE	HEAT	PARENT LIST ID	NET WEIGHT	OUTSIDE PROCESSOR ID											
729941-03-001	21	7592253	729941-03	3.285 LBS. 1.480 KG.	19L00356501											
729941-03-002	21	7592253	729941-03	3.260 LBS. 1.479 KG.	19L00356502											
729941-03-003	21	7592253	729941-03	3.275 LBS. 1.486 KG.	19L00356503											
729941-03-004	21	7592253	729941-03	3.270 LBS. 1.483 KG.	19L00356504											
729941-03-005	21	7592253	729941-03	3.275 LBS. 1.486 KG.	19L00356505											
729941-03-006	21	7592253	729941-03	3.275 LBS. 1.486 KG.	19L00356506											
729941-03-007	21	7592253	729941-03	3.275 LBS. 1.486 KG.	19L00356507											
729941-03-008	21	7592253	729941-03	3.280 LBS. 1.488 KG.	19L00356508											
729941-03-009	8	7592253	729941-03	1.250 LBS. 567 KG.	19L00356509											
TOTAL LISTS	TOTAL PIECES			TOTAL NET WEIGHT												
9	176			27.425 LBS. 12.449 KG.												
L-Ladle Analysis of Heat: P-Product Analysis of Parent Coil CHEMICAL ANALYSIS																
ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
E 7592253	.030	1.11	.025	.001	.48	17.55	7.12	.19	.033	.24						
UPMX Reviewed/Approved by QC Reviewed Specification(s) All Checked by: <i>Net V...</i> Pages 3 Date: 10/23/2019 TW METALS 49426595 MAR 18 2020 JH ACCEPTED BY																

DAS
82
9-89

*** CONTINUED ON NEXT PAGE ***

United Performance Metals

Paul Isaac
Quality Associate

Customer Name: TW Metals - Exton
Customer PO: M49426696
UPM Sales Order: 765822
Date: 3/17/2020
Description/Form: STAINLESS 301 1/2 HARD - SHEET
Heat Number: 7592253 Ingot: 19L00356506

Width: 96.0000 Length: 120.0000
Size: .1250
Customer P/N:
Packing List Number: 143348-1
Quantity: 1092 LB: 7 pc.

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 16 Coshocton, OH 43812 U.S.A.		Page: 2 Lead No: 5391843 Srt No: 5391843						
		MILL ORDER NO: 271940-3395 PROCESSOR ORDER NO: CIN-35836-P14 BUYERS ORDER NO: CIN-35836-P14 PART NO: ENGLISH UNITS -PRODUCT- METRIC UNITS .1250 NOM. 36.0000 X 120.0000								
CUSTOMER UNITED PERFORMANCE METALS INC 3475 SYMMES RD HAMILTON, OH 43015	SHIP TO UNITED PERFORMANCE METALS O'NEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 43015	SHIPPING DATE: 10/25/2019								
		REMARKS THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A. (DFARS 252.225.7001, 7008 & 7009 COMPLIANT). NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL. COILED PRODUCTS CONTAIN NO WELDS STEELMAKING PROCESS - EAF MELTED, AOD REFINED, CONTINUOUS CAST SLABS STAINLESS STEELS SUPPLIED BY AK STEEL CORPORATION COMPLY WITH THE EUROPEAN END-OF-LIFE VEHICLE DIRECTIVE 2000/53/EC (ELVD) AND THE RESTRICTION OF HAZARDOUS SUBSTANCES DIRECTIVE KNOWN AS EU-DIRECTIVE 2011/65/EU, EFFECTIVE JANUARY 3, 2013 (ROHS 2) RESIDUAL LEVELS OF Hg, Pb, Cd, & HEXAVALENT CHROMIUM ARE WITHIN ACCEPTABLE LIMITS ACCORDING TO THESE DIRECTIVES. AK STEEL HAS IMPLEMENTED, OPERATES AND MAINTAINS A QUALITY MANAGEMENT SYSTEM IN ACCORDANCE WITH THE REQUIREMENTS OF THE PRESSURE EQUIPMENT DIRECTIVE (PED) 97/23/EC 7/2, ANNEX I, PARAGRAPH 4.1. MATERIAL SUPPLIED IN ACCORDANCE WITH EN 10204:2004 TYPE 3.1 UPM-QRS-001 REV. B, EXCEPTIONS DATED AND APPROVED ON 02/22/2018.								
PRODUCT DESCRIPTION CR SET TYPE 301 STAINLESS NI 7.0% MIN TR FINIS 1/2 HARD SLIT EDGE * ASTM A 240-18 UNS S30100 CHEMISTRY ONLY * ASME SA-240 SECT. ION IT PART * 2017 EDITION CHEMISTRY ONLY * ASME SA-666 SECT. II PART A 2017 EDITION * ASTM F 899-12B (UNS S30100 TYPE 301) * AMS 5518 * ASTM A 666-15 * MIL-S-5059 D-AMEND-3 CANCELED * QQ-S-766-D (CANCELED) * UNS-S30100 13TH EDITION * UPM-301-1/2HD 06-04-08										
PARENT-LIFT ID	POS (L, T, D)	DIR (L, T, D)	COND A.S.T.M	% ELONG 19.3	ELONG METHOD MEASURED	ELONG GAUGE LENGTH 2 Inch	TENSILE STRENGTH (KSI) 167.6	Y.S. 2% OFFSET (KSI) 130.4	ROCKWELL HARDNESS C 36	ROCKWELL HARDNESS C 35
										

*** CONTINUED ON NEXT PAGE ***

DAS
82
9-89

United Performance Metals

Paul Isaacs
Quality Associate

Customer Name: TW Metals - Exton
Customer PO: M48426596
UPM Sales Order: 755822
Date: 3/17/2020
Description/Form: STAINLESS 301 1/2 HARD - SHEET
Heat Number: 7592253 Ingot: 19L00356506

Width: 36.0000 Length: 120.0000
Size: .1250
Customer P/N:
Packing List Number: 143346-1
Quantity: 1092 LB: 7 pc.

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 15 Coshocton, OH 43812 U.S.A.		Page: 3						
				Load No. 5391843 Scr No. 5391843						
C U S T O M E R	UNITED PERFORMANCE METALS INC 3475 SYMMES RD HAMILTON, OH 45015		UNITED PERFORMANCE METALS C'NEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 45015		MILL ORDER NO. 271940-3395 PROCESSOR ORDER NO. CIN-35836-P14 BUYERS ORDER NO. CIN-35836-P14 PART NO. ENGLISH UNITS: .1250 NOM 36.0000 X 120.0000 -PRODUCT- METRIC UNITS					
	PARENT LIFT ID	POS	DIR (L, T, D)	COND	BEND 90°					
	729941-03	T		A.S.T.M	PASS					
	PARENT LIFT ID	POS	DIR (L, T, D)	COND	% ELONG	ELONG METHOD	ELONG GAUGE LENGTH	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS TAIL
729941-03	F	T	A.S.T.M	24.1	MEASURED	2 Inch	169.2	125.6	C. 36	C. 35
PARENT LIFT ID	POS	DIR (L, T, D)	COND	BEND 90°						
729941-03	F		A.S.T.M	PASS						

TW METALS
 49436595
 MAR 18 2020
 JH
 ACCEPTED BY

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED.

AK Steel Corporation 919-425-5000 MRC 04/04/2019 1/74
Register Weblog LAMM 1.14

THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK Steel Corporation TO AVOID THE LIABILITY OF MISUSE OR COUNTERFEITING OF THE REPORT TO A THIRD PARTY IT MUST BE RECEIVED BY AND UNDER THE NAME OF SUCH CONSIGNEE.

SIGNED  DATE 12/25/2019 TIME 10:20 PM
CHRISTOPHER J. RICH QUALITY MANAGER

DAS
82
9-82

Entered:

JEDate: NOV 25 2020

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8680Route update only ☐

Job: <u>214 790</u> Part No. <u>648-3535</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier Quality ☐		
Date : <u>20-11-12</u>	Sequence #: <u>130</u>	QTY Affected : <u>1</u>	MRB (QS1042) DAS 9 9-88 <u>20-11-12</u>	
Description Work Order Deviation Was found at machining that one hole was .001" over tolerance. R.C. no QCB off after water jet		Disposition Scrap qty 1 no replace		Completed By <u>AHA</u> <u>20-11-12</u> Lead hand / Supervisor <u>B.A</u> <u>20-11-12</u> QC / QA Coordinator DAS 9 9-88 <u>20-11-12</u>
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				